Item ID:

D205-634-041

Accept



Setup Start





Revision ID:

Item Name:

Replacement Skidtube

Start Pate:

Start Otv: 1.00

Reg'd Oty: 1.00

Cussisem ID: Cussomer:

Reference:

Approvats:

QC:

Required Date. 26/01/28 10

Date: 10-1-08 Tooling:

Date:

Date:

Run

Stop

Sequence ID/

Operation Description Set Up/ Run Hours

SPC (Y/N):

Draw Number

Date:

Rev.

**Draw** Plan Code

Accept Qty

Reject Qty

Reject insø. Number Stamp

Work Center ID Draw Nbr

Revision Nor

D2580 Rev D

DOCUMENT CONTROL

DC

Memo

0.00

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

110

CNC Bend I

BENDING MACHINE - SKIDTUBES

Memo

0.00

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT099

2-Cut tubes as per Dwg. D2580

W/O:			WORK ORDER CHANGES							
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								:		
Part No	):	PAR #:	Fault Category:	NCR: Yes	s No <b>DQ</b>	A:	Date: _			
	Resolution	:	Disposition:	QA: N/C	Closed:		Date: _			

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description  Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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#### Work Order ID 55168

January 8, 2010 10:14:18 AM

Required Date: 26/01/2010

Item ID:

D205-634-041

Accept



Setup Start





Revision ID:

Item Name:

Replacement Skidtube

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Start

Reference:

Approvals:

Start Date:
Required D

Process Plan:

08/01/2010

Date:

Tooling:

Date:



QC:

SPC (Y/N):

Date:

Draw

Rev.

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ Ran Hours Draw Number Plan Code

Qty

Qty

Run

Reject Reject

insp. Stamp Number

120

Skidtubes

Skidtubes

Memo

Date:

0.00

0.00

1- Deburr ends

- 2- C'sink holes as per dwg without cutting fluid
- 3- Prepare tube for welding, remove alodine as required.
- 4- Scribe batch number insied aft end of tube.

130

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

<b>Dart Aerospace</b>	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			

Part No:	PAR #: Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

CR: WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC Corrective Action Section B			Verification	Annroyal	Approval	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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#### Work Order ID 55168

January 8, 2010 10:14:18 AM

Item ID:

D205-634-041

Accept

Setup Start





Revision ID:

Replacement Skidtube Item Name:

Required Date: 26/01/2010

Cust Item ID: Customer:

Reference:

Approvals:

Start Date:

Process Plan:

Date:

Tooling:

Date:

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Reject

Qty

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**  Draw Number

Draw Rev.

Plan Code

Accept Qty

Res

Number Stamp

insp.

140

Skidtubes Skidtubes

Memo

0.00

0.00

i-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R□□□ Aluminum Rod

A/R 🗆 🗆 🗀 Aluminum Rod

M112860

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI

M112860

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass/3/8" drill

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web.Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for af cap using DT 8215Open holes to 0.208". Debut

7-Drill pilot holes for Towring using DT8091, open to .640" and Deburr

HUM 10-1-21

ospace	Ltd							. *	
		W	ORK ORDER CHANGES	3					
STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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l	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _		
Re	solution:	Disposition: Q			QA: N/C Closed: Date:				
		WORK ORD	ER NON-CONFORMAN	CE (NCF	R)				
	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	, I		Chief Eng	QC Inspector	
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	STEP	PAR #: Resolution:	STEP PROCEDURE CHA  PROCEDURE CHA  PAR #: Fault Cate  Resolution: Disposition  WORK ORD  STEP Description of NC Section A Initial	WORK ORDER CHANGES  STEP PROCEDURE CHANGE	WORK ORDER CHANGES   By	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date  PAR #: Fault Category: NCR: Yes No DQ.  Resolution: Disposition: QA: N/C Closed:  WORK ORDER NON-CONFORMANCE (NCR)  STEP Description of NC Section A Corrective Action Section B Section B Section A Section A Section B Sec	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr	

#### Work Order ID 55168

January 8, 2010 10:14:18 AM

Item ID:

D205-634-041

Accept



Setup Start



Stop



Revision ID:

Replacement Skidtube Item Name:

Start Date:

08/01/2016 Start Oty: 1.00

Required Date: 26/01/2016 Req'd Qty: 1.00



Cust teen ID: Customer:

Reference:

Approvais:

Date:

Tooling:

Date:

Start

Run



Date:

SPC (Y/N):

Date:

Stop

Reject

Qty

Sequence ID/ Work Center ID

150

Operation Description

QC10- Inspect visual per QSI004- ground welds

Set Up/ Run Hours Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Number Stamp

Quality Control

160

QC

**Quality Control** 

QC5- Inspect part completeness to step on W/O

170

HandFinish Hand Finishing Pressure Wash per QSI005 4.3

Memo

Memo

Memo

by 10-01-26

Dart	Aeros	pace	Ltd
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W/O:			WORK ORDER CHANGE									
DATÈ	STEP	PRO	ROCEDURE CHANGE			у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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				1.5								
Part No	:	PAR #:	Fault Category: N			es N	o <b>DQ</b> .	A:	Date:			
	R	esolution:	Dispositi	on:	QA: N/C Closed: Date:							
NCR:		\	WORK ORE	DER NON-CONFORM	ANCE (N	ICR)						
DATE	STEP	Description of NC		tion B Verificatio			cation	Approval	Approval			
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date		ion C	Chief Eng	QC Inspector		
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Required Date: 26/01/2010

Item ID:

D205-634-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Replacement Skidtube

Start & c.e:

08/01/2010

Start Oty: 1.00

Req'd Qty: 1.00



Cust Item ID: Customer:

Draw

Number



Refei ence:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

Date:

Start Run

Reject

Qty

QC:

Date:

SPC (Y/N):

Date:

Draw

Rev.

Stop



Number Stamp

Insp.

Reject

Sequence ID/ Work Center ID

180

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

11113170

Set Up/ Run Hours

10-01-27

Accept

Qty

Plan

Code

Memo

7:00Am 3209 START TIME: OVEN TEMPERATURE: FINISH TIME: 7:30Au

190

Quality Control

QC

Memo

QC3- Inspect Part Finish

Bil 10-01-28.

Dart	Aero	ospa	ce	Ltd
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W/O:	ŀ	WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	<u> </u>	PAR #:	Fault Cate	egory:	NC	R: Yes	No <b>DO</b>	Δ-	Date:					
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NCR:				ER NON-CONFORM										
DATE	STEP Description of NC					tion B Verificati			Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	<b>1</b>	Sign & Date		Section C	Chief Eng	QC Inspector				
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							i.							

#### Work Order ID 55168

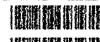
January 8, 2010 10:14:18 AM

Item ID:

D205-634-041

Accept

Setup Start



Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Qty: 1.00 Start Date: 08/01/2010 Required Date: 26/01/2010

Reg'd Qty: 1.00



Date:

Cust Items ID: Customer:

Start

Reference:

Approvals:

Process Plan:

QC:

Date:

Tooling: SPC (Y/N):

Date: Date:

Stop

Run

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours** 

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

200

HandFinish

Hand Finishing

Memo

0.00

0.00

I-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of-Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with

Sikaflex. Clean excess adhesive Sikaflex-291 Sikaflex expire date: 10/09.

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: M 113 345.

Bl 10-0-28 0.

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		PAR #:	Fault Category: NCR:			Yes	No DQ	<b>A</b> :	Date:				
Resolution:			Disposition	l:	_ QA: I	WC Cld	osed:		Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE	(NCR	)						
	T	Description of NC Section A	Corrective Action Section E		on B		Verific	ation	Approval	Approval			
DATE	STEP		Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector			
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Item ID:

D205-634-041

Accept

Setup Start



Stop

Revision ID:

Item Name:

Replacement Skidtube

Start Date:

Required Date: 26/01/2010 Req'd Qty: 1.00

08/01/2010 Mart Oty: 1.00

Reference:

Approvals:

Date:

Tooling:

Date:

Start

Run

QC: \_\_\_

Date:

SPC (Y/N):

Date:

Stop

Reject

Qty

16-2-8

Sequence ID/

**Work Center ID** 

210

OC

**Quality Control** 

Operation Description

Set Up/ **Run Hours**  Draw Number

Draw Rev.

Pian Code

Accept Qty

Number Stamp

Memo

0.00

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for

Foreign objects per QSI 024

QC5- inspect part completeness to step on W/O

220

Packaging Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPPD205-634-041

Location: PPP Rev

230

QC21- Final Inspection - Work Order Release

0.00

Quality Control

QC

Memo

0.00

MF 10-2-0x

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				·				7	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	\:	Date:	
Resolution:									
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	<b>R</b> )		, p.,,****	
DATE	STEP	Description of NC		Corrective Action Section		Verific	Verification	Approval	Approval
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Picklist Print											Page
January 8, 2010 10	):14:23 AM										_
Work Order ID: 55	5168										
Parent Item: D.	205-634-041										
Parent Item Name:	Replacement Skidti	ube	1 54 2 10 14 7 16 17 16 17	MANY ANG SWEETS SCHOOL HILL BIRLI	IIBBH SEM GJERI MEI (56	•	Si	art Date: 08/	01/2010	Required Date	26/01/2014
Comments	IPP Rev:N 02.08. IPP Rev:O 06.02 IPP Rev:P 07-07	2.28 Added paper		***	KJ		<b>S</b>	itart Qty: 1.00		Required Qty	.00
Component: Item ID/ D2580-1  205 Skidtube berg detail		Mfg/ Manufactured	Bin Prima No		Route 110	Unit of Each	<b>Qty on</b> 11.0000	Remaining	Qty	Date	Status
			<u> 14</u>	arehouse	Loc	Qty	Loc Code				
				Location							
			М	ain Warehouse							
				LG		7		-		_	
				54120		i		-		_	/
				54541		2		7	Awm	10-1-1	4
				54648 <sub>,</sub> 54697		2 2		1	7 / 1	_10-5-1	0
			М	ain Warehouse		_		-		-	
				ST		4					
				54500		2					
				54647		2		_		_	
D2576-3		Manufactured	No		140	Each	151.0000	1.0000			

Step (maching detail)

Loc Oty	Loc Code	
151		
3		
101		BE 10.0/-
47		
	151 3 101	151 3 101

Dart Ae	rospace	e Ltd							.*				
W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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	;												
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date:					
	R	esolution:	Dispositi	_ QA: N/C Closed: Date:									
NCR:		V	VORK ORD	DER NON-CONFORMAI	NCE (NCR	)							
		Description of NC		Corrective Action Section	Section B			Ammuoval	Annuaral				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector				
							:						

Work Order ID: 55168

Parent Item:

D205-634-041

Parent Item Name: Replacement Skidtube

Comments:

IPP Rev:N 02.08.28 FP was QC5 in Step 23: Added QC5 to Step 30 UKJ

IPP Rev:P 07-07-09 SS Wearplates & GEkets JLM

Manufactured

IPP Rev. O 06.02.28 Added paperwork & EC

Replacement Mfg/ Bin Primary

No

Component Item ID/ D2579

Crossbolt Spacer

	1	
	WI	

Last

Start Bate: 08/01/2010

Required Date: 26/01/2010

Required Qty: 1.00 Start Qty: 1.00

Remaining Qty on

Unit of

Each

Route

140

381.0000 20.0000

Date Status

Warehouse	Loc Ocy	Loc Code			
Location					
Main Warehouse					
LG	259				
51525	4		****		
53780	3		****		
54543	38				. / / /
54642	214		_20	Ok	20/10/01/20
Main Warehouse					/ / /
ST	122				
43988	4				
46434	4				
46956	2				
47797	9				
48272	2				
51314	7 i				
51315	30		-		

W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	) <b>:</b>	PAR #:	Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date:				
	Resolution		Disposition	O A . N/O /	Nood:		Data				

	WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	Approval	Approval QC Inspector		
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Work Order ID: 55168

Primary

Parent Item:

D205-634-041

Parent Item Name: Comments:

Replacement Skidtube

IPP Rev:N □ 02.0 2 28 □ FP was QC5 in Step 27; Added QC5 to Step 30 □ KJ IPP Rev. O 06. \$28 Added paperwork EC

IPP Rev:P 074-09 SS Wearplates & Gaskets ILM

Start Date: 08/01/2010

Required Date: 26/01/2010

Start Oty: 1.00

Required Oty: 1.00

Component Item ID/ D2855

Replacement Mfg/

Bin Manufactured

Last

Route Unit of 200 Each

159.0000 1.0000

Remaining

Status

Cap

Warehouse	Loc	Qty:	Loc Code	
Location				
Main Warehouse				
FP6		159		
50513		ı		
50770		1		
51539		42		
53791		115		
	200	Each	1.965.000 2	00

AN3-5A

Purchased

No

Bolt

Warehouse	Loc Oty	Loc Code
<b>Location</b>		
Main Warehouse		
ST	1965	
100188	188	
105057	1777	

IB 10-01-28.

	•									•
W/O:			WO	RK ORDER CHAN	GES					
DATE STEP		PRO	PROCEDURE CHANGE			C	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Categ	NCR: Yes No DQA:				Date:		
Resolution:			Disposition	<b>]:</b>	QA: N/C	Close	ed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	IANCE (N	CR)				
DATE	STEP	Description of NC Section A	Corrective Action Solution Initial Action Description		ction B	ın &	Verification Section C		Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	D	ate	Section	<u> </u>	Criter Eng	QC inspector
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Picklist Print				Page 4
January 8, 2010 10:14:23 AM				
Work Order ID: 55168				
Parent Item: D205-634-041				:
Parent Item Name: Replacement Skidtube	i spaike leib 1984 arabi and amble ande 1994 riet sier	BU MBUU MBBU 1/91 13/94	Start Date: 08/01/2010	Required Date: 26/01/2010
Comments: 62 IPP Rev:N\(\pi\)02.08.28\(\pi\)FP was QC5 ii	n Step 27; Added QC5 to Step 30 H	KJ ₄.	Start Qty: 1.00	Required Qty: 1.00 and
IPP Rev. O 06.02.28 Added pape		The same of		
Component Ite*: ID/ Replacement Mfg/	Bin Primary Last	Route Unit of	Qty on Remaining Qty	Date Status
AN960JD10L Purchased	No	200 Each	4,741.000 2.0000	•
Washer				
	Warehouse	Loc Oty	Loc Code	
	<b>Location</b>			
	Main Warehouse			
	ST	4741		
	101291	16		
	104885 105793	16 105	<u></u>	/ /
	109632	170		- /2/10-α-28.
	110985	4434	2	-// 10-α-08.
ALS7-1032-130 Purchased	No	200 Each	1,494.000 50.0000	,
Insert				
	Warehouse	Lee Oty	Loc Code	
	<u>Location</u>			
	Main Warehouse			
	ST	1494		
	105855	16		
	108606	52		<del></del>
	111529	152	<del> </del>	<del></del>
	111779 112772	313 11		
	113238	950		<del></del>
AL54-1037-130	110 511		50	bil 10-01-28.
January 8, 2010 10:14:23 AM	Shop Pa	acket Print		Page 4

W/O:			WO	RK ORDER CHAI	NGES					<u>.</u>
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Category:			R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
	R	esolution:	Disposition	l:	QA:	N/C CI	osed:		Date:	·····
NCR:		V	VORK ORDE	R NON-CONFOR	MANCE	(NCR	)			·
DATE	STEP	Description of NC			Section B		Verifi	cation	Approval	Approval
DAIL	SILP	Section A	Initial Chief Eng	Action Description Chief Eng	on	Sign & Date		ion C	Chief Eng	QC Inspector
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Work Order ID: 55168

Parent Item:

Comments:

D205-634-041

Parent Item Name: Replacement Skidtube

IPP Rev:N:02.08.28 GFP was QC5 in Step 27; Added QC5 to Step 30 GKJ IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev.P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 08/01/2010

Required Date: 26/01/2010

Required Qty: 1.00

Component Item ID/ AN3C4A

Replacement Mfg/

Purchased

Purchased

Bin Primary No

Last

Route 200

Unit of Each

Oty on 1,181.000 50.0000

Remaining

Start Oty: 1.00

Qty

Date

Status

BOLT

Warehouse	Lo	c Qty	Loc Code	
Location				
Main Warehouse				
ST		1181		
112314		13		
112720		12		
112724		3		
112829		1		
112991		2		
113121		64		
113226		586		
113422		500		
	200	Each	388.0000	50.0000

AN960C10L

No

160

washer

	Warehouse		roc Och	Lor Code
	Location			
NAS1149C0332R	OFFSHORE FG	113286	100	
	10358	35	100	
	Main Warehous	se		
	ST		288	
	11211	16	128	

112612

50 ph 10-01-28

W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							·				
		WHA									
Part No	:	PAR #:	Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date: _				
	Resolution	):	Disposition:	QA: N/C (	losed:		Date: _				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	Verification Approval	Annroyal	Annroyal				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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Work Order ID: 55168

Parent Item:

Comments:

D205-634-041

Parent Item Name: Replacement Skidtube

IPP Rev:N \_02.08.28 TFR vas QC5 in Step 27; Added QC5 to Step 30 TKJ

IPP Rev. O 06.02.28 Added paperwork EC IPP Rev.P 07-07-09 S Wearplates & Gaskets JLM

Manufactured

Start Date: 08/01/2010

Required Date: 26/01/2010

\$\art Qty: 1.00

Required Oty: 1.00

Component Item ID/

Replacement Mfg

Bin Primary Last

Route 200

Unit of

Qty on Remaining Qty

Status

D3566-13

Manufactured

No

Each

93.0000 1.0000

Date

Gasket

Warehouse	Loc	Oty	Lor Code		
Location					
Main Warehouse					
FP /		91			
51 <b>986</b>		Ģ			# BK 10-01-28
53461		82			
Main Warehouse					
ST		2			
45717		1			
50265		1			
	200	Each	14.0000	1.0000	

D3566-5

Gasket

Warehouse	Loc Qtv	Loc Code
Location		
Main Warehouse		
FP 55026	10	
53804	10	
Main Warehouse		
ST	4	
36113	ŧ	
46186	1	
47318	i	
51260	1	

1 bil 10-01-28.

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	g/ Applotal					
							14					
4.						,						
					Tro-Alline 1-1							
Part No	•	PAR #:	Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date: _					

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	Verification	Ammuoval	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
								:			
								;			

Work Order ID: 55168

Parent Item:

Comments:

D205-634-041

Parent Item Name:

Replacement Skidtube

IRR Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 TKJ

BERev. O 06.02.28 Added paperwork EC Illy kev:P 07-07-09 SS Wearplates & Gaskets

Start Date: 08/01/2010

Required Date: 26/01/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Replacement Mfg/

Manufactured

Manufactured

Primary Bin No

Last

Route 200

Unit of

Each

Qty on Remaining 25.0000 2.0000

Status

D3566-1

Gasket

Wareho	use	Loc	: Qty	Loc Code		
Loc	ation					10
Main W	archouse 55011		20			2 BK 15-01-28.
	52512 54480		3 17			
Main W	arehouse					
ST			5			
	46349		1			
	51218		I			
	51259		3			
		200	Each	15.0000	1.0000	

Wearshoe

D3564-11

Warehouse Location	Loc Qty	Lox Code	
Main Warehouse			
FP19 /	13		1 bl 10-01-28.
52125	13		1 10-01-03.
Main Warehouse			
ST	2		
45823	1		
50112	1		

Dart	Aer	osp	ace	Ltd
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	•								
W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		1							, ,
<u>.</u>									
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	٨:	Date: _	<u></u>
	R	esolution:	Disposition	:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	7)		··· · · · · · · · · · · · · · · · · ·	
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector
			7						
t	İ	1							1

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ν	10	١L	1	st	ν	2.3	n.	k

Page 8

January 8, 2010 10:14:23 AM

Work Order ID: 55168

Parent Item:

Comments:

D205-634-041

Parent Item Name: Replacement Skidtube

IPP Rev. O 06.02.28 Added paperwork EC

IPP Rev:P 07-07-09 SS Wezzplates & Gaskets ILM

IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to step 30 KJ

Start Date: 08/01/2010

Start Oty: 1.00

Required Date: 26/01/2010

Required Oty: 1.00

Camponent Item ID/ D3564-13

Replacement Mfg/

Manufactured

Manufactured

Bin Primary

L#.st

Route 200

Unit of Each

Each

Qty on 33.0000

Remaining 1.0000

-- hel 10-01-28

Status

Wearshoe

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse		
FP17 /	21	
51611	21	
Main Warehouse		
ST	12	
45409	2	
46495	10	

D3564-9

Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19	10	
53806	10	
Main Warehouse		
ST	2	
44659	1	
45825	1	

200

12.0000 1.0000

1 bl 100038.

**Shop Packet Print** 

Dart Aerospace Ltd	Dart	Aero	space	Ltd
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W/O:	ŀ		WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		,							
Part No		PAR #:							
	Resolution: Disposition:			•	QA: N/C Closed:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)		***	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	cription Sign &		Verification Section C		Approval QC Inspector
			Officer Eng	Ciller Eng	Date				
							: I		
									:
		71							
		j							
								······································	

Work Order ID: 55168

Parent Item:

D205-634-041

Comments:

Parent Item Name: Replacement Skidtube

IPP Rev:N⊕02.08.28 □FP was QC5 in Step 27; Added QC5 to Step 30' KJ IPP Rev. O 06.02.28 Added paper crk EC

IPP Rev.P 67-07-09 SS Wearphie's & Gaskets JLM

Manufactured

Start Date: 08/01/2010

Required Date: 26/01/2010

Start Qty: 1.39

Required Qty: 1.00

Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Qty Date Component Item ID/ Status 13.0000 1.0000 No 200 Each D3564-5 Manufactured

Wearshoe

Warehouse	Loc	: Oty	Loc Code		
Location					
OFFSHORE					n hel
FG 54772		2			1 Bl 10-01-28
34806		2			
Main Warehouse					
FP19		9			
51925		1			
53805		8			
Main Warehouse					
ST		2			
45824		t			
47433		ł			<del></del>
	200	Each	346.0000	16.0000	

D2594-3

O-Ring, 205 Skidtube

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	27	
51613	27	
Main Warehouse		
ST /	319	
52562 🗸	319	

16 pl 16-01-28.

	-								•
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,			i		
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	A:	Date:	
	Re	esolution:	Dispositio	n:	_ QA: N/C (	Closed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector
I									
	- (8)								
	1								f

Work Order ID: 55168

Parent Item:

Comments:

D205-634-041

Primary

Parent Item Name: Replacement Skidtube

IPP Rev:N 162.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

IPP Rev. O. 346.02.28 Added paperwork EC

IPP Rev:P 327-07-09 SS Wearplates & Gaskets JLM

Route

200

Oty on

Remaining

Required Date: 26/01/2010

Required Qty: 1.00

Date

Component Item ID/ D2594-1

Replacement Mfg/

Bin No Manufactured

Last

Unit of Each

234.0000 16.0000

Start Date: 08/01/2010 Start Qty: 1.00

Status

Plug, 205 Skidtube

Warehouse	Loc Qty	Lor Code	
Location			/ 1
Main Warehouse			16. 15/ 10-01-28
FP \$5000	106		1- 10/10 00 00
54008	1		
54643	105		According to the Actual
Main Warehouse			
ST	128		and the second s
42221	16		
42807	92		
43884	3		
46435	2		
51527	9		
51757	6		

Dart Aerospace Ltd	נ
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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	PROCEDURE CHANGE						Approval QC Inspector
٠.									
			. 1/00			19.11			
				· · · · · · · · · · · · · · · · · · ·					
Part No	·	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	٨:	_ Date: _	·
	Resc	olution:	Disposition	:	QA: N/C CI	osed:	F	Date: _	
NCR:				R NON-CONFORMAN	ICE (NCF	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section	B Sign 8	Verific		Approval	Approval
		Section A	Chief Eng	Action Description  Chief Eng	Date	Section	on C	Chief Eng	QC Inspector
	:								



	DESIG	*#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHEC	KED.	APPROVED	DRAWING NO. REV. D
				D2580 SHEET 1 OF 3
	DATE	· · · · · · · · · · · · · · · · · · ·		TITLE SCALE
	07.0	2.27		205 SKIDTUBE ASSEMBLY NTS
	Α		96.09.16	NEW ISSUE
	В		96.12.02	AS MANUFACTURED
	C		98.08.26	REDRAWN, INCLUDED DEO 9094/9097
	D		07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183



QTY I -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130	INSERT
		or AKS7-1032-130	
		or AKS4-1032-130	
L		or AELS-1032-130	
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COLY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

# SENSRAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:

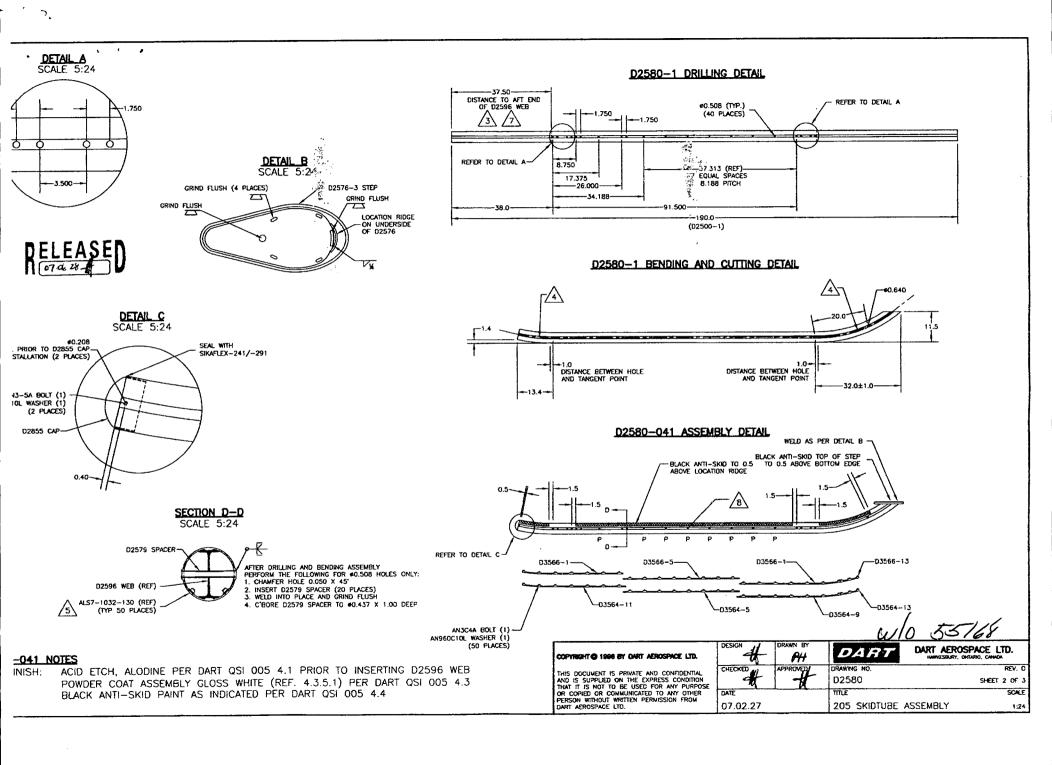
SEE NOTES ON

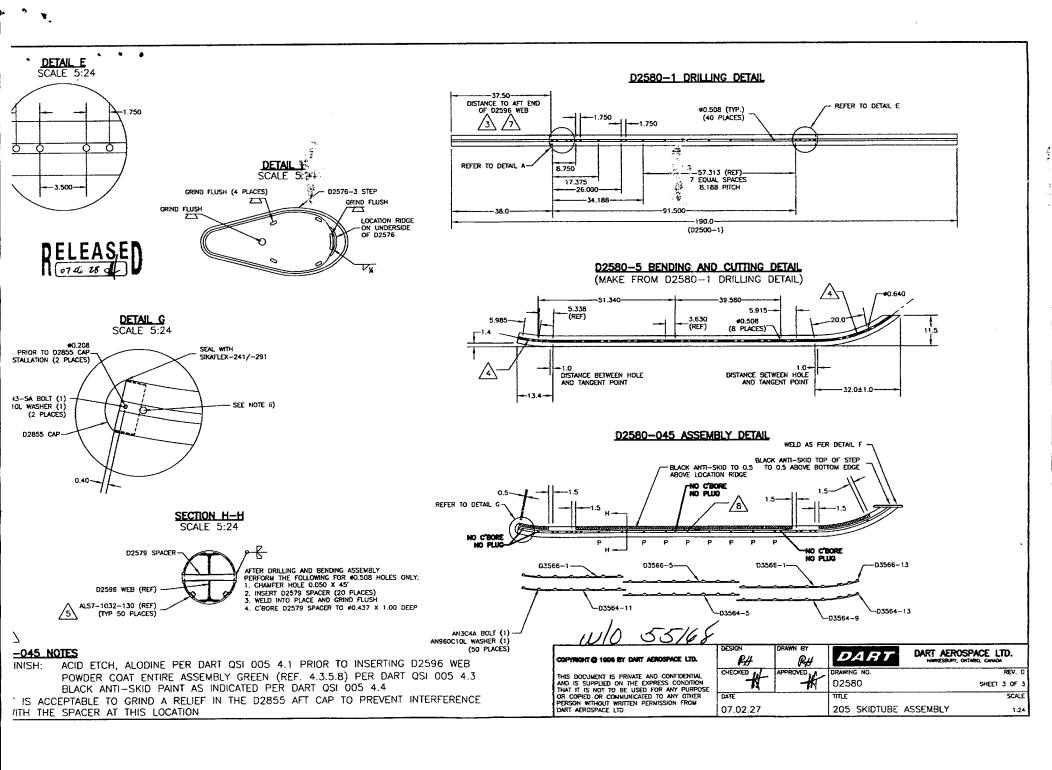
PAGE 2 FOR D2580-041 AND PAGE 3 FOR D2580-045

 INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NO. 221
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# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Borday Elliott					
Job number: 542023					
Part number: Daos 634 041					
Description: 205 Skid tube					
Welding Process: Tig Mig ]					
Base materiel: Aluminian					
Current: AC[ / DC[ ]					

# TEST REQUIREMENTS AND RESULTS

Visual: Penetration:	pass[] fail[] pass[] fail[]
<u>UNACCEPTABLE</u>	
Cracks: Undercut: Pin holes: Overlap (cold lap) Porosity (surface): Coloration:	pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[] pass[] fail[]
Qualifier (o) )	Date of Test Coupon C9.12.17  Date of Test Coupon C9.12.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld